Work Order ID 48590B

Friday, June 26, 2009 11:52:04 AM

Item ID: D3822-2KIV
Revision ID: ~~B~~ C
Item Name: Vertical Tunnel, RH-Ivory

Accept

Setup **Start**
Stop

Start Date: 7/15/2009 **Start Qty:** 3.00
Required Date: 8/3/2009 **Req'd Qty:** 3.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
100 Thermoform Thermoforming Machine	**Memo** Machine Set-Up	0.00 0.00	BB 09/07/02						
110 Thermoform Thermoforming Machine	**Memo** 1-Cut Sheet to required Blank size	0.00 0.00	BB 09/07/02 X3 M109703						
120 Thermoform Thermoforming Machine	**Memo** Thermoform as per Dwg and Folio #FTA026 using tool DT9074 Dwg Rev: C Folio Rev: B	0.00 0.00	BB 09/07/02 X 3						

Work Order ID 48590B

Friday, June 26, 2009 11:52:04 AM

Item ID: D3822-2KIV
Revision ID: ~~B~~ C 19
Item Name: Vertical Tunnel, RH-Ivory

Accept

Setup **Start**
Stop

Start Date: 7/15/2009 **Start Qty:** 3.00
Required Date: 8/3/2009 **Req'd Qty:** 3.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	BB 09/07/09 X3								
140	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control	DL 09/07/08. X5								
150		0.00							
Thermoform	Memo	0.00							
Thermoforming Machine	1-Trim to finished dimensions as per Dwg								
	BB 09/07/09 X3								

Work Order ID 48590B

Friday, June 26, 2009 11:52:04 AM

Item ID: D3822-2KIV
Revision ID: ~~B~~ C 01
Item Name: Vertical Tunnel, RH-Ivory

Accept

Setup **Start**
Stop

Start Date: 7/15/2009 **Start Qty:** 3.00
Required Date: 8/3/2009 **Req'd Qty:** 3.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00	BB 09/07/09		(X3)				
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00	S 09/07/09		(x3)	(RM)			
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location:_____	0.00				9/7/9	(3x)	54	
Packaging	Memo	0.00							
Packaging									

Work Order ID 48590B

Friday, June 26, 2009 11:52:04 AM

Item ID: D3822-2KIV
Revision ID: ~~B~~ C 01.
Item Name: Vertical Tunnel, RH-Ivory

Accept

Setup **Start**
Stop

Start Date: 7/15/2009 **Start Qty:** 3.00
Required Date: 8/3/2009 **Req'd Qty:** 3.00
Reference:

Cust Item ID:
Customer:

Run **Start**
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00				09/07/09			
QC Quality Control	**Memo**	0.00							

L 9.07.09

Picklist Print

Friday, June 26, 2009 11:52:03 AM

Work Order ID: 48590B

Parent Item: D3822-2KIVRev~~B~~C DL

Parent Item Name: Vertical Tunnel, RH-Ivory

Start Date: 7/15/2009 **Required Date:** 8/3/2009

Comments: Est Rev:C Add Colour Code 09-06-02 DL

Start Qty: 3.00 **Required Qty:** 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	0.0000	23.4117			
6185 KYDEX .080"												

JB 09/07/09 X3

Date: Monday, 15/06/2009 4:19:48 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 48590B
Estimate Number : 13586
P.O. Number :
This Issue : 15/06/2009 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : THERMOFORMING
Previous Run : 47672B
Written By :
Checked & Approved By : JW 09.06.15
Comment : Est. A New Issue 08/09/17 DL
Rev B Dwg. Update 09/02/09 DL verified by:DD
Est. Rev C Add Colour Code 09/06/02 DL

Drawing Name : VERTICAL TUNNEL R/H, IVORY
Part Number : D38222KIV
Drawing Number : D3822-2
Project Number :
Drawing Revision : ~~B~~ C
Material : MKYD6185S080P362015
Due Date : 22/06/2009 **Qty:** ~~6~~ 3 **Um:** Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	MKYD6185S080P362015	6185 KYDEX .080"

Comment: Qty.: 7.4028 sf(s)/Unit Total : 37.0140 sf(s)
6185 Kydex .080" Ivory BB M109703

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING

Comment: HAND FINISHING THERMOFORMING
1) Machine set up BB 09/07/01

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING

Comment: HAND FINISHING THERMOFORMING
1) Cut sheet to required blank size BB 09/07/01 X3

4.0	THERMOFORMING	THERMOFORMING MACHINE

Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-2and folio FTA 026 using tool DT 9074

Dwg. Rev. C
Folio Rev. B BB 09/07/03 X3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 15/06/2009 4:19:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** VERTICAL TUNNEL R/H, IVORY

Job Number: 48590B **Part Number:** D38222KIV

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part BB 09/07/01 X3

6.0	QC8	SECOND CHECK

Comment: SECOND CHECK 09/07/08. X3

7.0	HAND FINISH TH	HAND FINISHING THERMOFORMING

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions BB 09/07/09 X3

8.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances. BB 09/07/09 X3

9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP Sorlolos X3

10.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:_____

11.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	48590B
Description:	Part Number:	D 3822-2 K112
Inspection Dwg: 3822 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 09/07/09

TRIMMING SECTION

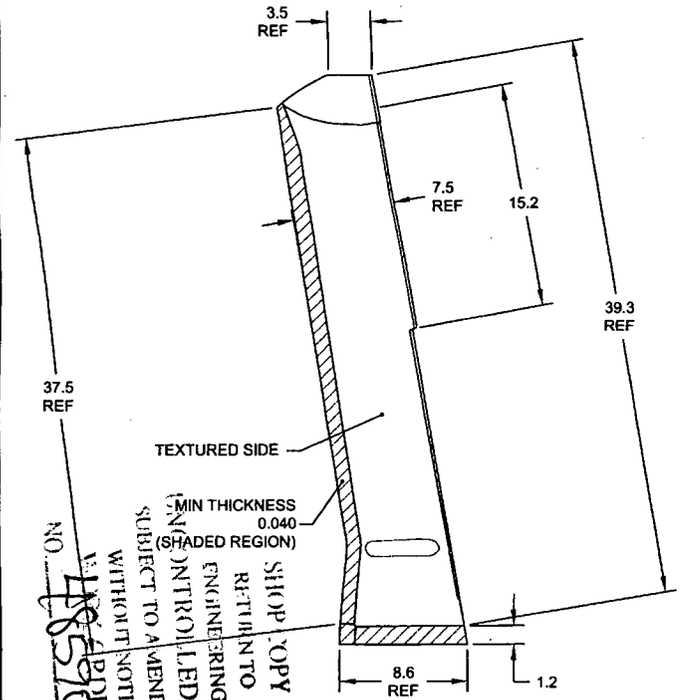
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.040	Min	.050	✓			
.050.	Min	.062	✓			
0.80	Min	.992	✓			
0.3	Min	.355	✓			
.55	Min	.766	✓			

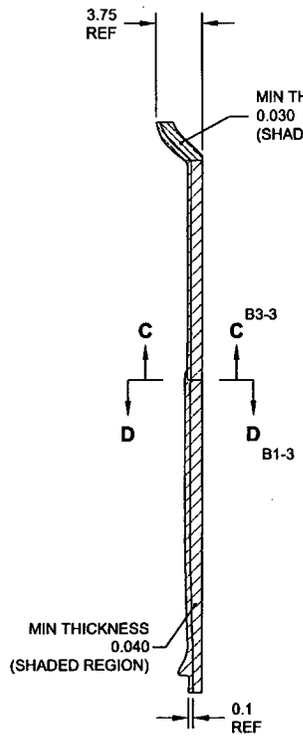
Measured by: BB Date: 09/07/09

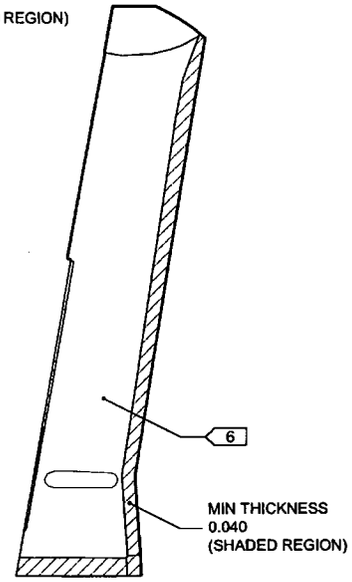
Audited by: S Date: 09/07/09

Prototype Approval: n/a Date: n/a

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	







D3822-2 VERTICAL TUNNEL, RH
(BELL 206 A/B)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 1185708

RELEASED
09/05/22

NOTES:
1) MATERIAL: SEE TABLE
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
7) WEIGHT: 1.1 lbs
8) TOOLING: THERMOFORM PER MOLD DT9074 PER DART QSI 022. TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

	PART NUMBER	DESCRIPTION
C	D3822-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
C	D3822-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RH	
CHECKED		DRAWING NO. D3822 — REV. C — SHEET 2 OF 6
MFG. APPR.		
APPROVED		TITLE: VERTICAL TUNNEL (BELL 206 A/B) — SCALE: NTS
DE APPR.		
DATE	09.05.05	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

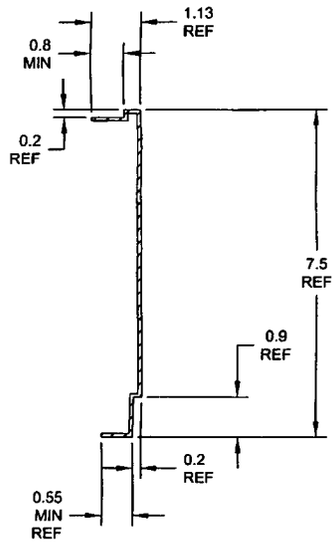
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

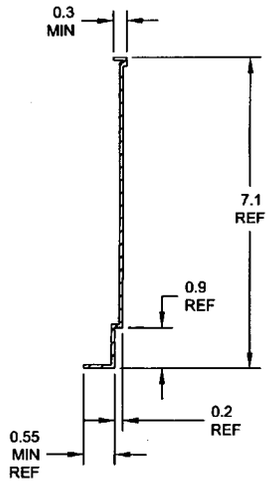
NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



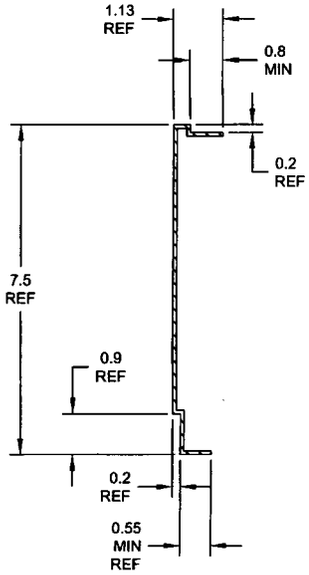
C6-1

SECTION A-A



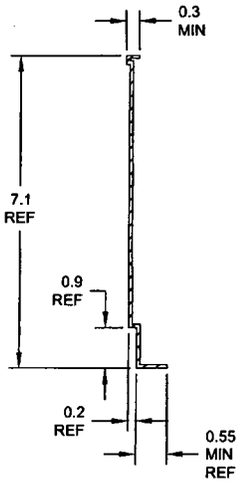
C6-1

SECTION B-B



C4-2

SECTION C-C



C4-2

SECTION D-D

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78558-03

RELEASED
09/05/12 NR

DESIGN	RG	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RG	
CHECKED		DRAWING NO. D3822 — REV. C — SHEET 3 OF 6
MFG. APPR.		
APPROVED		TITLE: VERTICAL TUNNEL (BELL 206 A/B) — SCALE: NTS
DE APPR.		
DATE	09.05.05	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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